

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-005746**Date Inspected:** 12-Mar-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1830**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 630**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Chen Chien and Huaq Wein Pang			CWI Present:	Yes	No
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No N/A
				Delayed / Cancelled:	Yes	No N/A
Bridge No:	34-0006			Component:	OBG Assembly, Tower	

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector Joe Alaniz was present during the times noted above for observations relative to the work being performed.

This QA Inspector performed Ultrasonic Testing (UT) on approximately 15% of CJP West Tower Lift 2 Skin E welds previously accepted by ZPMC ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6. 3. The QA Inspector observed no rejectable indications at the time of testing. The QA Inspector generated a TL-6027 UT report on this date. Welds UT verified were identified as listed below.

Bay 11

WSD1-SA298E/G:

1(A/B), 6(A/B), 10(A/B), 13(A/B), 14(A/B), 19(A/B) and 23(A/B)

WSD1-SA298E/G:

1(A/B), 6(A/B) and 12(A/B)

This QA Inspector observed the following work in progress:

Bay 11

ZPMC's welding personnel's Mrs. Yang Meizhen (042195) and Mr. Xue Yien (040634) performing groove welding of weld joint ESD1-TL7B/L/K-44B filler passes. The personnel were observed welding in the 1G (flat)

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position utilizing a Submerged Arc Welding (SAW) process. ZPMC QC identified Mr. Li Le and was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-7-2221-B-U3G-2.

Bay 13

ZPMC qualified welding personnel identified as Mr. Qie Jianzhou (067571) perform SMAW welding on weld joints identified SSDA5A-PP10.5-004. ZPMC QC identified Mr. Shen Fu You was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2112.

Bay 14

ZPMC qualified welding personnel identified as Mr. Yang Chang Ming (058242) perform SMAW tack welding on weld joint identified SEG003*-002. ZPMC QC identified Mr. Shen Fu You was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2211-1G.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (134-8257-0045), who represents the Office of Structural Materials for your project.

Inspected By:	Alaniz,Joe	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
